

**Work Order ID 75560****\*75560\***

Tuesday, October 25, 2011 11:43:28 AM

Ship Nov 2011  
Page 1

Item ID: D412-742-013

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Float Skidtube Installation

Start Date: 10/25/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: *MP* Date: *11-10-25* Tooling:

Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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IIN D412-742	D
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100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-742-013 CHG006

*W 11 11 01 (1)*  
*Per MLT 11-10-27*  
*11/10/28*

110

Pick Kit

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*W 11 11 01 (1)*

**B75563**

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 75560

**\*75560\***

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Item ID: D412-742-013

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Float Skidtube Installation

Start Date: 10/25/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-013 Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

SP11-11-1

11/11/01

MF 11-11-01

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Work Order ID: 75560

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/25/2011

Required Date: 10/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A05.10.13New Issue KJ/JLM  
 IPP Rev:B 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN 1072 DD  
 verified by:JLM  
 IPP Rev:D 08-09-08 ecn 08-510 DD verified by:EC  
 IPP Rev:E 09-01-23 as per DSI9441 DD verified by:EC IPP RevF: add AN4C7A DD 10.01.13  
 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C7A Bolt		Purchased	No			110	Each	331.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST356		331							
				109147		331							
D412-742-043 Replacement Float Skidtube		Manufactured	No			110	Each	0.0000	1	1			
D2571 Saddle, Fwd Out 205		Manufactured	No			110	Each	7.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST433		7							
				72969		7							
D2572 Saddle, Fwd In 205		Manufactured	No			110	Each	4.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST433		4							
				71107		2							
				72968		2							
D2573 Saddle, Aft Out 205		Manufactured	No			110	Each	3.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST434		3							
				72936		3							

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Work Order ID: 75560

Parent Item: D412-742-013

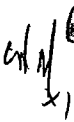
Start Date: 10/25/2011

Required Date: 10/28/2011

Parent Item Name: Float Skidtube Installation

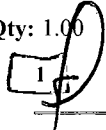
Start Qty: 1.00

Required Qty: 1.00

 **D2574**  
Saddle, Aft In 205

Manufactured No

110 Each 3.0000

 1

Location

Loc Qty

Loc Code

ST434

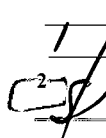
3

72937

3

Manufactured No

110 Each 31.0000

 2

Location

Loc Qty

Loc Code

ST025

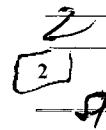
31

72136

31

Manufactured No

110 Each 95.0000

 2

Location

Loc Qty

Loc Code

ST025

95

72135

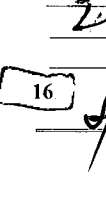
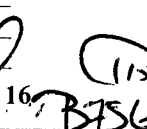
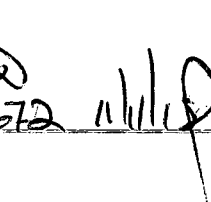
29

73309

66

Manufactured No

110 Each 36.0000

 16  112  11111

Location

Loc Qty

Loc Code

ST052

36

70696

29

71350


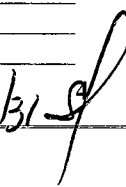
1

71842

6

Manufactured No

110 Each 142.0000

 4  11111

Location

Loc Qty

Loc Code

ST021

142

71163

42

73495

100

 **D2747**  
Set Screw

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 75560

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/25/2011

Required Date: 10/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3533-1

Set Screw

Manufactured No

110 Each 92.0000

2 2

Location

Loc Qty

Loc Code

ST065

92

73310

92

Purchased No

110 Each 442.0000

16 16

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

438

116704

15

118451

123

118983

100

119328

200

Purchased No

110 Each 93.0000

8 8

Location

Loc Qty

Loc Code

ST361

93

117163

36

117688

7

118451

50

Purchased No

110 Each 48.0000

8 8

Location

Loc Qty

Loc Code

ST341

48

118422

48

AN4C6A

Bolt

AN4C52A

BOLT

AN6C12A

BOLT

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Work Order ID: 75560

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/25/2011

Required Date: 10/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-3  
Phenolic Washer

Manufactured No

110 Each 867.0000

32 32

Location

Loc Qty

Loc Code

ST074

867

64176

180

72230

187

73487

500

AN960C416L NAS1149C0432R

WASHER

D3672-9

Phenolic Washer

Purchased No

110 Each 0.0000

32 32

Manufactured No

110 Each 264.0000

8 8

Location

Loc Qty

Loc Code

ST074

264

35523

264

NAS1149C0632R

WASHER

Purchased No

110 Each 120.0000

8 8

Location

Loc Qty

Loc Code

ST297

120

118006

120

D3672-11

Phenolic Washer

Manufactured No

110 Each 163.0000

16 16

Location

Loc Qty

Loc Code

ST074

163

58046

163

MS21043-4

Nut

Purchased No

110 Each 1,319.0000

28 28

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1279

117793

279

118686

500

119309

500

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 75560

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/25/2011

Required Date: 10/28/2011

Start Qty: 1.00

Required Qty: 1.00

**D3403-3**  
Bushing

Manufactured No

110 Each 37.0000

8  
8

Location

Loc Qty

Loc Code

ST 5  
69509 5  
ST052 32  
71852 32

**D3405-041**  
Lug Assembly

Manufactured No

110 Each 16.0000

8  
1 1

Location

Loc Qty

Loc Code

ST423 3  
70980 3  
ST474 13  
62227 2  
73338 11

**D3405-043**  
Lug Assembly

Manufactured No

110 Each 10.0000

1 1

Location

Loc Qty

Loc Code

ST423 2  
65703 2  
ST478 8  
73339 8

**AN4C47A**  
Bolt

Purchased No

110 Each 73.0000

4 4

Location

Loc Qty

Loc Code

ST361 73  
117163 23  
118451 50

**D3407-041**  
Tow Ring

Manufactured No

110 Each 4.0000

1 1 1/2 8

Location

Loc Qty

Loc Code

ST463 4  
73340 4

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 75560

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/25/2011

Required Date: 10/28/2011

Start Qty: 1.00

Required Qty: 1.00

**D3417-3** Washer Manufactured No 110 Each 68.0000 2 2

Location	Loc Qty	Loc Code
FG	9	
33519	9	
ST053	59	
51648	12	
53182	23	
66847	24	

**D3456-1** Washer Manufactured No 110 Each 118.0000 1 1

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST054	111	
66848	3	
71165	8	
73493	100	

**AN3C37A** BOLT Purchased No 110 Each 137.0000 1 1

Location	Loc Qty	Loc Code
ST354	137	
116874	11	
117010	2	
118518	49	
118709	50	
119324	25	

**AN3C40A** BOLT Purchased No 110 Each 77.0000 1 1

Location	Loc Qty	Loc Code
ST354	77	
112454	27	
114442	50	

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Work Order ID: 75560

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/25/2011

Required Date: 10/28/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C41A  
BOLT

Purchased

No

110

Each

134.0000

1

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

130

119035

80

119324

50

AN3C42A

BOLT

Purchased

No

110

Each

43.0000

1

Location

Loc Qty

Loc Code

ST354

43

106176

1

117763

20

118131

20

118451

2

AN3C43A

BOLT

Purchased

No

110

Each

53.0000

4

Location

Loc Qty

Loc Code

ST354

53

114455

20

117688

8

118387

25

AN3C46A

BOLT

Purchased

No

110

Each

67.0000

5

Location

Loc Qty

Loc Code

ST355

67

118757

17

118758

50

AN960C10L

washer

NAS1149C0332R

Purchased

No

110

Each

0.0000

26

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**Dart Aerospace Ltd**

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Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/25/2011

Required Date: 10/28/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

110

Each

903.0000

13

15

Nut

## Location

## Loc Qty

## Loc Code

FG

72

103691

72

ST301

831

118077

1

118614

482

118686

348

13

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Item	Qty -013	Qty -043	Part Number	Description
40	1		D2571	SADDLE, FWD OUTSIDE
41	1		D2572	SADDLE, FWD INSIDE
42	1		D2573	SADDLE, AFT OUTSIDE
43	1		D2574	SADDLE, AFT INSIDE
44	2		D2876	SADDLE SPACER
45	2		D2877	SADDLE SPACER
46	16		D3403-1	BUSHING
47A	4		D2747	SET SCREW
47B	2		D3533-1	SET SCREW
48	16		AN4C6A	BOLT
49	8		AN4C52A	BOLT
50	8		AN6C12A	BOLT
51A	32		D3672-3	WASHER (REPLACES NAS1515H4L)
51B	32		AN960C416L	WASHER
52A	8		D3672-9	WASHER (REPLACES NAS1515H6L)
52B	8		AN960C616L	WASHER
53	16		D3672-11	WASHER (REPLACES NAS1515H7L)
54	24		MS21043-4	NUT
55	4		ANC47A	BOLT
60	8		D3403-3	BUSHING
61	1		D3405-041	GHW LUG
62	1		D3405-043	GHW LUG
63	4		AN4C46A	BOLT
64	4		MS21043-4	NUT
70	1		D3407-041	TOW RING
71	2		D3417-3	WASHER
72	1		MS21043-4	NUT
73	1		D3456-1	WASHER
91	1		AN3C37A	BOLT
92	1		AN3C40A	BOLT
93	1		AN3C41A	BOLT
94	1		AN3C42A	BOLT
95	4		AN3C43A	BOLT
97	5		AN3C46A	BOLT
99	26		AN960C10L	WASHER
100	13		MS21043-3	NUT

\*DENOTES PART IS INCLUDED WITH D3391-043 ASSEMBLY ABOVE

\*\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

## 5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

Item	Qty -013	Qty -043	Part Number	Description
	X		D412-742-013 J	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043 J	FLOAT SKIDTUBE
		1	D3391-043	412 FLOAT SKIDTUBE
1		*24	*AN3C4A	*BOLT
3		*12	*AN3C6A	*BOLT
4		*8	*AN3C7A	*BOLT
5		*44	*AN960C10L	*WASHER
21A		*1	*D3564-1	*WEARSHOE (REPLACES D3460-1)
21B		*1	*D3566-1	*GASKET
22A		*1	*D3564-3	*WEARSHOE (REPLACES D3460-3)
22B		*1	*D3566-1	*GASKET
23A		*1	*D3564-5	*WEARSHOE (REPLACES D2577-5)
23B		*1	*D3566-5	*GASKET
10		*1	*D3391-021	*412 FORWARD TUBE
11		**1	**D3401-041	**TOW CAP
12A		**10	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB166)
12B		**2	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB166)
13		**10	**AN3C4A	**BOLT
14A		**4	**D3672-1	**WASHER (REPLACES NAS1515H3L)
14B		**10	**AN960C10L	**WASHER
24A		**1	**D3564-13	**WEARSHOE
24B		**1	**D3566-13	**GASKET
20		*1	*D3391-023	*412 MID TUBE
28		**20	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB116)
30		*1	*D3391-025	*412 AFT TUBE
25A		**1	*D3537-1	**WEARPAD
25B		**1	*D3553-1	**GASKET
26A		**1	*D3537-7	**WEARPAD
26B		**1	*D3553-3	**GASKET
31		**1	**D2646	**AFT CAP
32		**14	**AELS-1032-130	**INSERT
36		**12	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB366)
37A		**6	**AN3C4A	**BOLT
37B		**4	**AN3C5A	**BOLT
38A		**2	**D3672-1	**WASHER (REPLACES NAS1515H3L)
38B		**10	**AN960C10L	**WASHER

(CONTINUED ON PAGE 19)

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3.

REFERENCE ONLY

REF. FAA STC: SR01583SE  
REF. CANADIAN STC: SH05-37  
REF. EASA STC: EASA.IM.R.S.01126

## INSTRUCTIONS:

- 1) FOR D412-742-011/-013 SKIDTUBES @ CHANGE 006 AND SUBSEQUENT, UPDATE THE PARTS LIST TO MODIFY THE BOLT USED TO ATTACH THE GHW LUG AS FOLLOWS:

### 5.1 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List 32.15 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

ITEM	Qty -011	Qty -041	Qty -015	PART NUMBER	DESCRIPTION
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT

IS:

63	4			AN4C47A	BOLT
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WAS:

63	4			AN4C46A	BOLT
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### 5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List 32.16 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

ITEM	Qty -013	Qty 043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE

IS:

63	4		AN4C47A	BOLT
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WAS:

63	4		AN4C46A	BOLT
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A	NEW ISSUE	AJS	08.12.19
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9441	SHEET 1 OF 1
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## Mike Petsche

**From:** Linda Lacelle <llacelle@dartaero.com>  
**Sent:** Thursday, October 27, 2011 5:06 PM  
**To:** 'Mike Petsche'; dshepherd@dartaero.com  
**Subject:** FW: NEW PO 12248 FOR BRISTOW US LLC - CP/SH

fyi

**From:** Shirley Hay [<mailto:SHay@darths.com>]  
**Sent:** October-27-11 3:55 PM  
**To:** Linda Lacelle; Nancy MacLeod; [sbedford@dartaero.com](mailto:sbedford@dartaero.com); [mfauteux@dartaero.com](mailto:mfauteux@dartaero.com); 'Brigitte Golden'; [rmolnar@dartaero.com](mailto:rmolnar@dartaero.com)  
**Cc:** Linda Pilon; Carole O'Rourke; Carrie Pearson  
**Subject:** RE: NEW PO 12248 FOR BRISTOW US LLC - CP/SH

Hello

Please send out the old configuration

Regards  
Shirley Hay

**From:** Linda Lacelle [<mailto:llacelle@dartaero.com>]  
**Sent:** Wednesday, October 26, 2011 3:34 PM  
**To:** Nancy MacLeod; [sbedford@dartaero.com](mailto:sbedford@dartaero.com); [mfauteux@dartaero.com](mailto:mfauteux@dartaero.com); 'Brigitte Golden'; [rmolnar@dartaero.com](mailto:rmolnar@dartaero.com)  
**Cc:** Linda Pilon; Shirley Hay; Carole O'Rourke; Carrie Pearson  
**Subject:** RE: NEW PO 12248 FOR BRISTOW US LLC - CP/SH

There has been a recent engineering change on the float skids, and the earliest we can ship these would be the week Nov. 7<sup>th</sup>, or we ship the current CHG number with the old configuration of wearplates...please let mw know how you would like to proceed.

Linda

**From:** Nancy MacLeod [<mailto:NMacLeod@darths.com>]  
**Sent:** October-20-11 1:56 PM  
**To:** 'sbedford@dartaero.com'; 'llacelle@dartaero.com'; 'mfauteux@dartaero.com'; Brigitte Golden; [rmolnar@dartaero.com](mailto:rmolnar@dartaero.com)  
**Cc:** Linda Pilon; Shirley Hay; Carole O'Rourke; Carrie Pearson  
**Subject:** NEW PO 12248 FOR BRISTOW US LLC - CP/SH

Please see the attached PO for Bristow US LLC.

If you require any further information, please let me know. Thank you,